

Date: Thursday, 6/15/2006 1:50:18 PM
 User: Kim Johnston

Process Sheet

SLT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 27579		
Estimate Number	: 10256		
P.O. Number	: N/A	Part Number	: D22303
This Issue	: 6/15/2006 S.O. No. : N/A	Drawing Number	: D2230 REV F
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: F
Previous Run	: 26593 Type : MACHINED PARTS	Material	: N/A
Written By	<i>(See comment below)</i>		
Checked & Approved By	<i>(initials 06.06.15)</i>		
Comment	: Est D 06.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Batch: B23779	J-F 06/06/19 204
2.0	BAND SAW	BAND SAW	
		Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: B23779	J-F 06/06/19 204
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 PG issue P.O to Metec 204
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine.	RIO 1521 C206120104 (204)
4.0	QC	INSPECT PARTS AS THEY COME OFF MACHINE	 Receive + Inspect for finish damage 100
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	100
5.0	QC	SECOND CHECK	 J-F 07.10 100
		Comment: SECOND CHECK	100

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 06/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: MOUNTING LUG

Job Number: 27579

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



NIAZ

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAP 06/07/10

8.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

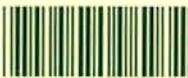
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06/07/10

(10c)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

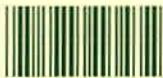


Comment: INSPECT POWDER COAT

Ref/7/11 100

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 371

Ref/7/11 100

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

G 06/07/12

Job Completion



W 06/07/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

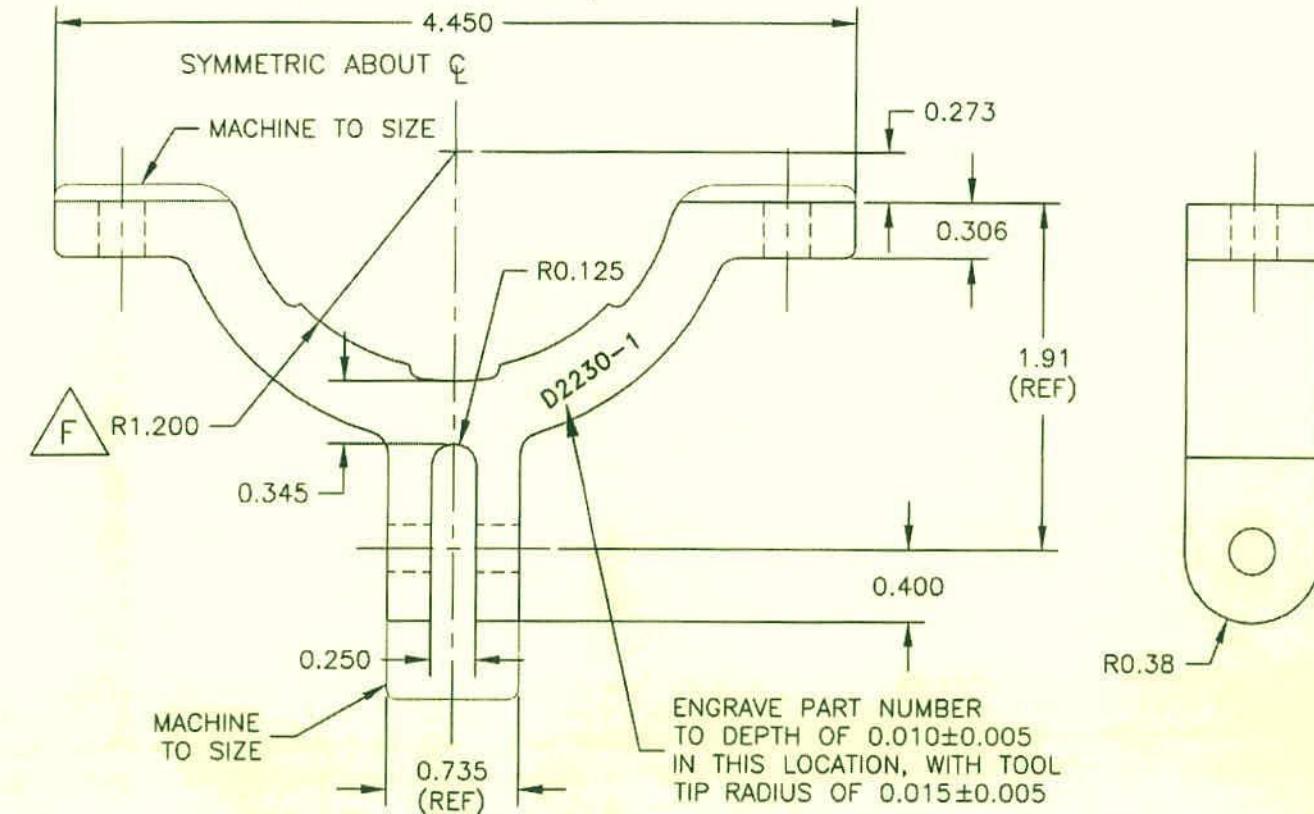
Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
		REV. F SHEET 1 OF 2
DATE		TITLE MOUNTING LUG
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

1999.12.21 PS



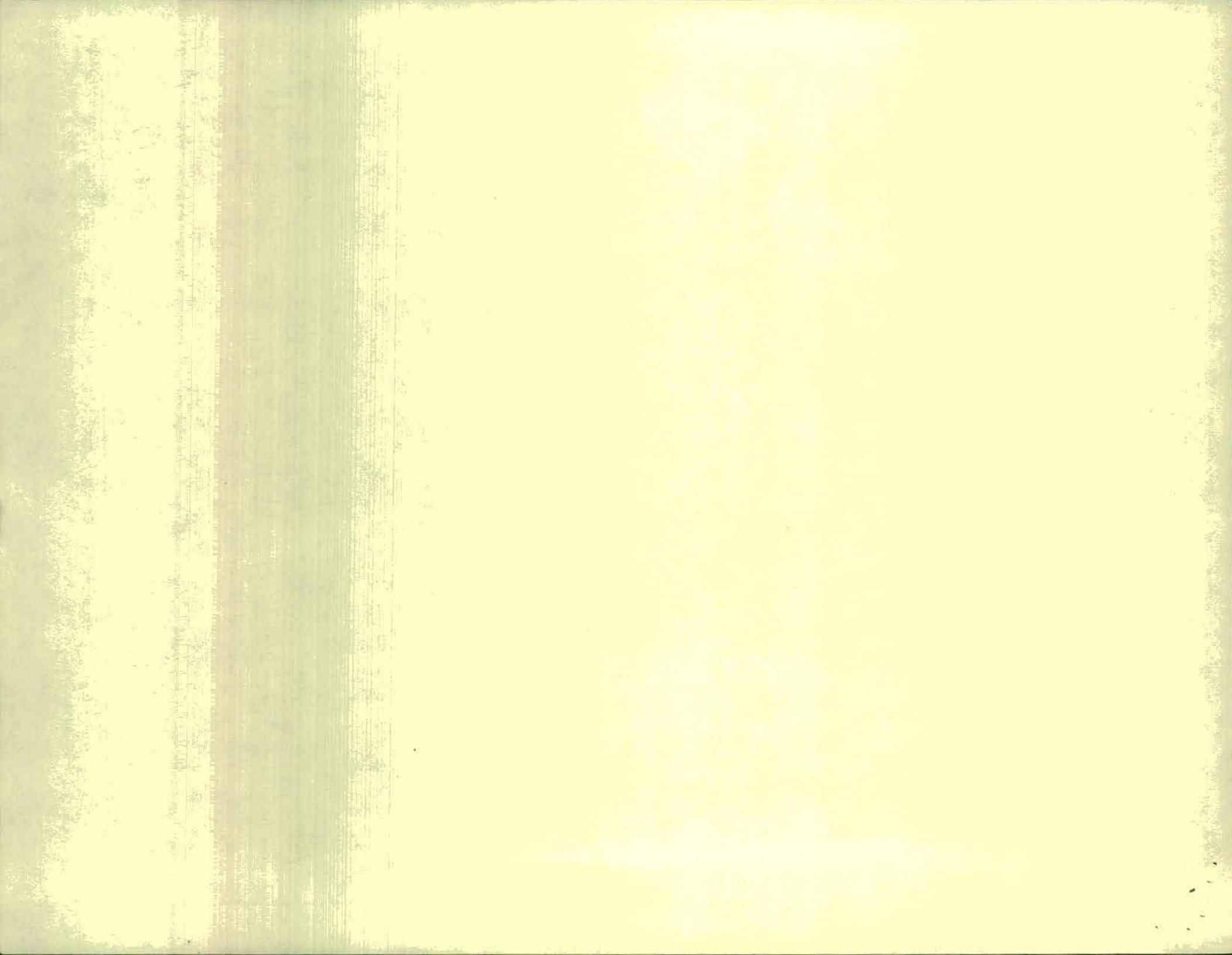
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27579



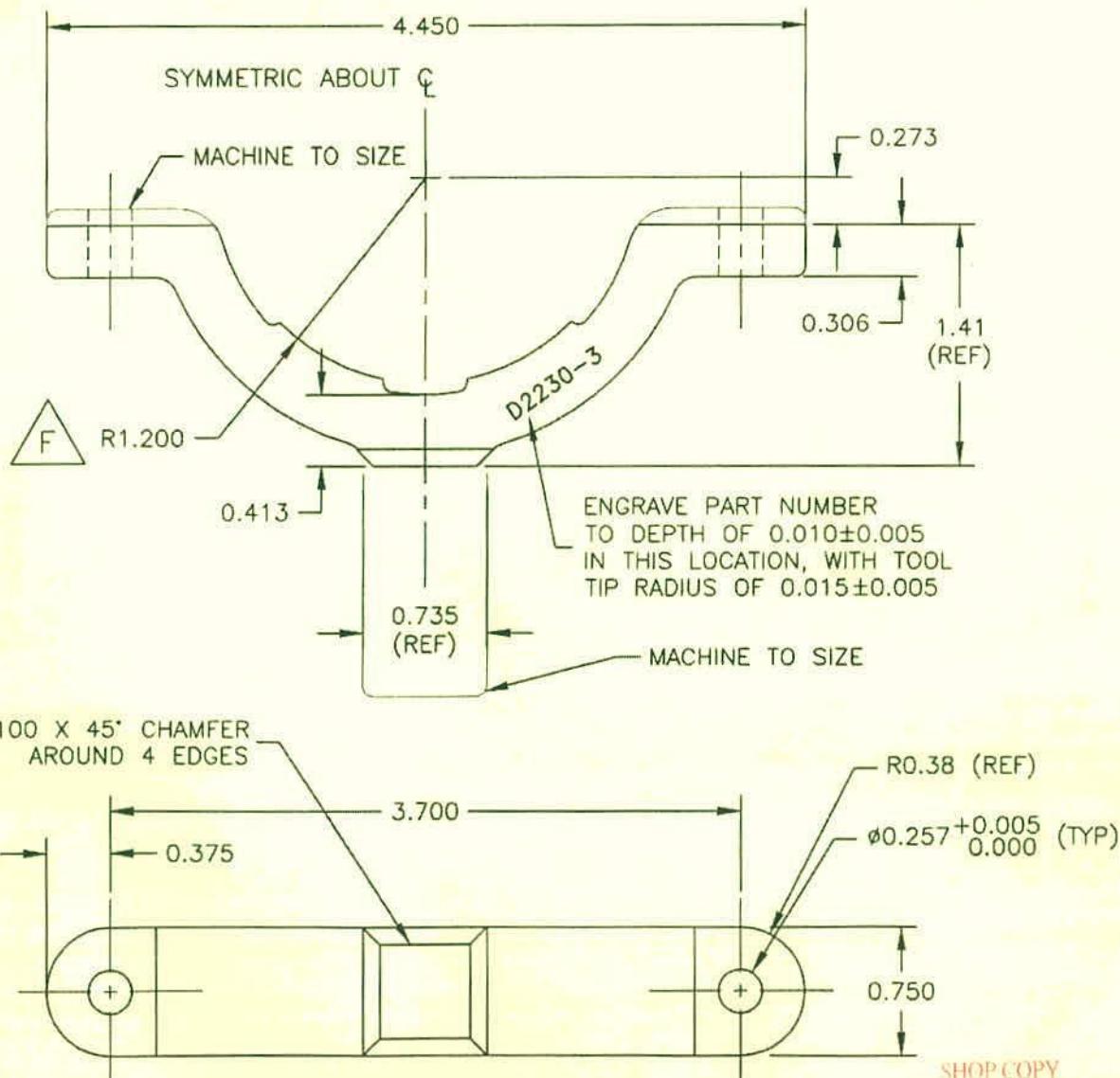
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 2 OF 2 TITLE MOUNTING LUG SCALE 1:1

99.12.13

RELEASED

99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____



**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D 2230-3	Mounting Lug	1521

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, July 7, 2006

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz". Below the signature, the date "06-07-06" is handwritten.

